

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017419**Date Inspected:** 13-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segments**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Dan Hernandez was present during the times noted above to observe the fit up, welding and related activities associated with the fabrication of the San Francisco Oakland Bay Self Anchored Suspension Bridge at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

OBG Trial Assembly Yard

Segment 10BW/10CW

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a fillet weld joint. The Weld joint is designated as OBW10E-003, 004, Diverter Plate. The welder is identified as #041713 and was observed welding in the 2F (horizontal) position using approved Welding Procedure Specification WPS-B-P-2112.

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as OBW10E-035, 032, Diverter Plate. The welder is identified as #041713 and was observed welding in the 3G (vertical) position using approved Welding Procedure Specification WPS-B-P-2213-B-U2-FCM-1.

Segment 10AW/10BW

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a fillet weld joint. The Weld

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joint is designated as OBW10D-032, 035, Diverter Plate. The welder is identified as #041713 and was observed welding in the 2F (horizontal) position using approved Welding Procedure Specification WPS-B-P-2112.

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as OBW10D-033, 034, Diverter Plate. The welder is identified as #041713 and was observed welding in the 3G (vertical) position using approved Welding Procedure Specification WPS-B-P-2213-B-U2-FCM-1.

Segment 10BE

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a Partial Joint Penetration (PJP) weld joint. The Weld joint is designated as RETRO-B3-10BE-044, Retro Plate. The welder is identified as #040581 and was observed welding in the 3G (vertical) position using approved Welding Procedure Specification WPS-B-P-2313-TC-P5.

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a fillet weld joint. The Weld joint is designated as EP156-001-014, 12, Edge Plate I-rib hold back welds. The welder is identified as #040270 and was observed welding in the 4F (overhead) position using approved Welding Procedure Specification WPS-B-P-2114-FCM-1.

Segment 10CE

This QA Inspector observed Base Metal Repair using the Shielded Metal Arc Welding (SMAW) process at locations of removed fit up plates along the exterior of the Deck Plate transverse CJP splice. The welder is identified as #040484 and was observed welding in the 1G (flat) position using approved Welding Procedure Specification WPS-345-SMAW-1G (1F)-FCM-repair-1 for CWR1799.

For the above mentioned welding activities ZPMC Quality Control (QC) Inspector is identified as An Qing Xiang. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Segment 10BE/10CE

This QA Inspector observed ZPMC personnel performing Magnetic Particle Testing on the Deck Plate I-rib hold back fillet welds, cross beam and bike path side.

Segment 10CE

This QA Inspector observed ZPMC personnel performing Magnetic Particle Testing on the Deck Plate at locations of removed fit up plates, at the 10CE/11AE field splice location.

Segment 11CW

This QA Inspector observed 11CW was placed in the trial assembly line up.

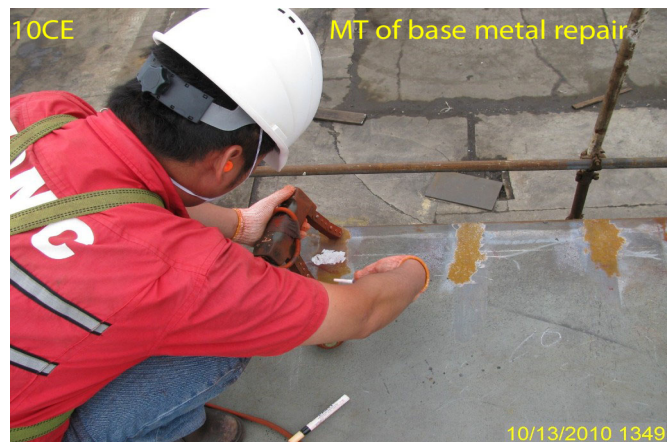
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Segment 11BE

This QA Inspector observed fit up of the bottom panel to FL3 flange at panel points 98 – 100.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150-0042-2372 , who represents the Office of Structural Materials for your project.

Inspected By: Hernandez,Dan

Quality Assurance Inspector

Reviewed By: Peterson,Art

QA Reviewer